

Work Order ID 80255

80255

Page 1

February-15-12 3:33:24 PM

Item ID: D2804-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 15/02/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/02/16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2804

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-2 into arm as per Dwg D2804

12/03/27 (3)

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8/26/27

(x3)

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

1h00

OVEN TEMPERATURE:

1h30 FINISH TIME:

320°F

M120222

3 ~~3~~ (AP) 12/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2804-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 15/02/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Press Fit D2809 as per Dwg D2804								
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.								

3 BL 12-3-09

ES 12/03/09 (3)

ES 12/03/09 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Item Name: Bracket Assembly
 Start Date: 15/02/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00	8/26/12			(X3)			
Quality Control						-012			

170	Identify as per dwg & Stock Location: ST/150	0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/12
 R12-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 80255

80255

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2		Manufactured	No			100	Each	12.0000	1	5			
D2804-2									**				
Bracket													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			2						
					77602		2						
				ST149			10						
					79180		10						
D2805-2		Manufactured	No			100	Each	17.0000	1	5			
D2805-2									**				
Stop													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			17						
					79526		17						
NAS1515H3		Purchased	No			100	Each	286.0000	4	20			
NAS1515H3									**				
Washer													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST277			286						
					118078		6						
					118384		11						
					119438		4						
					120142		99						
					120518		166						

EP 2/03/12

EP 2/03/12

EP 2/03/12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 80255

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Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

AN3C16A

Purchased

No

150

Each

109.0000

2

10

AN3C16A

Bolt

**

EP 12/03/29

Location

Loc Qty

Loc Code

ST352

109

115835

1

118422

4

119641

4

120498

100

D2809

Manufactured

No

150

Each

23.0000

1

5

D2809

Bushing

**

EP 12/03/29

Location

Loc Qty

Loc Code

GA

7

72735

7

ST018

16

34035

12

77292

4

B80557
(32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 80255

80255

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

MS21043-3

Purchased

No

150

Each

1,340.000

2

10

MS21043-3

Nut

**

EB 12/03/29

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

400

120693

400

ST300

373

119901

373

ST301

495

118077

2

118614

441

118686

30

119758

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

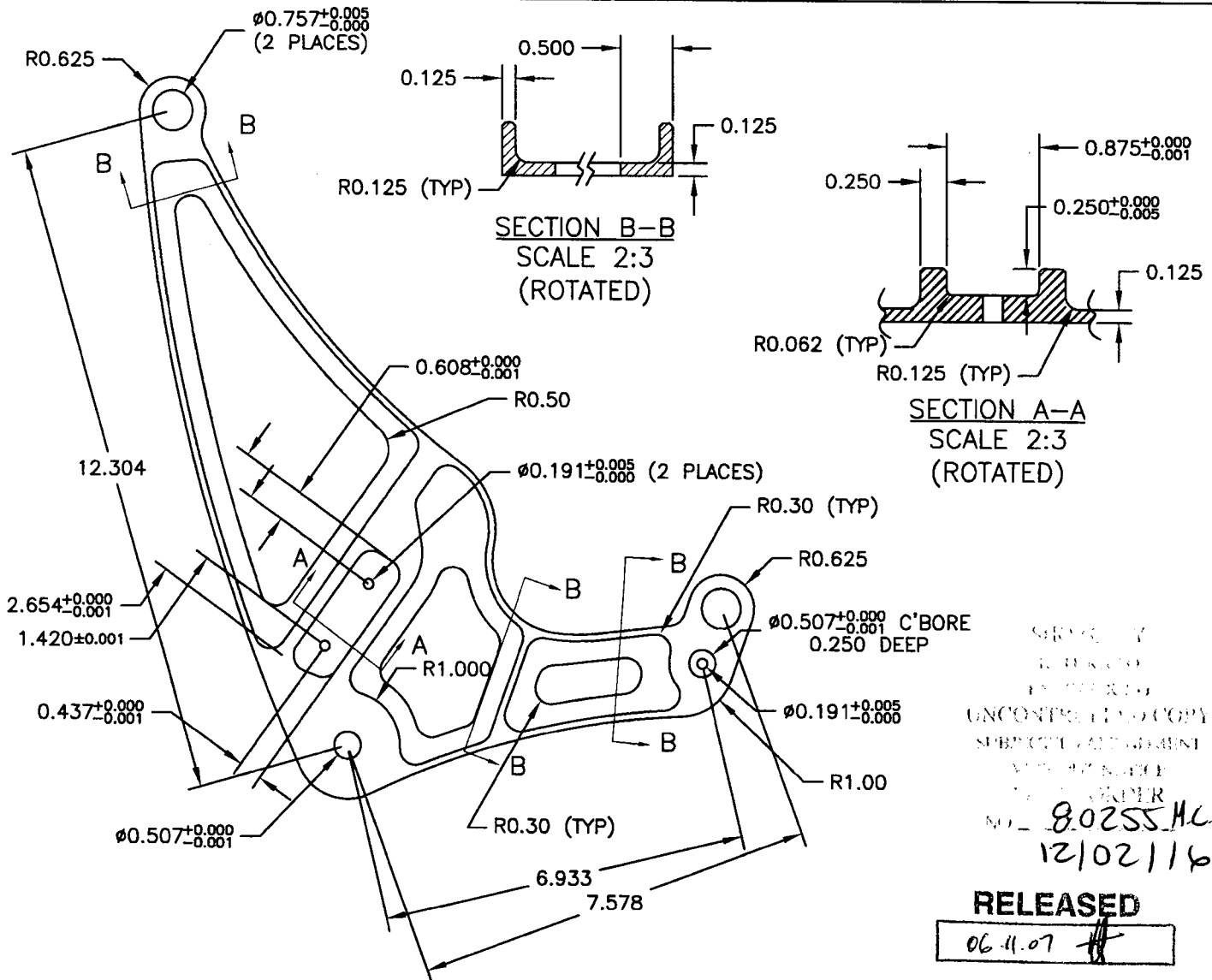
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPR" T
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

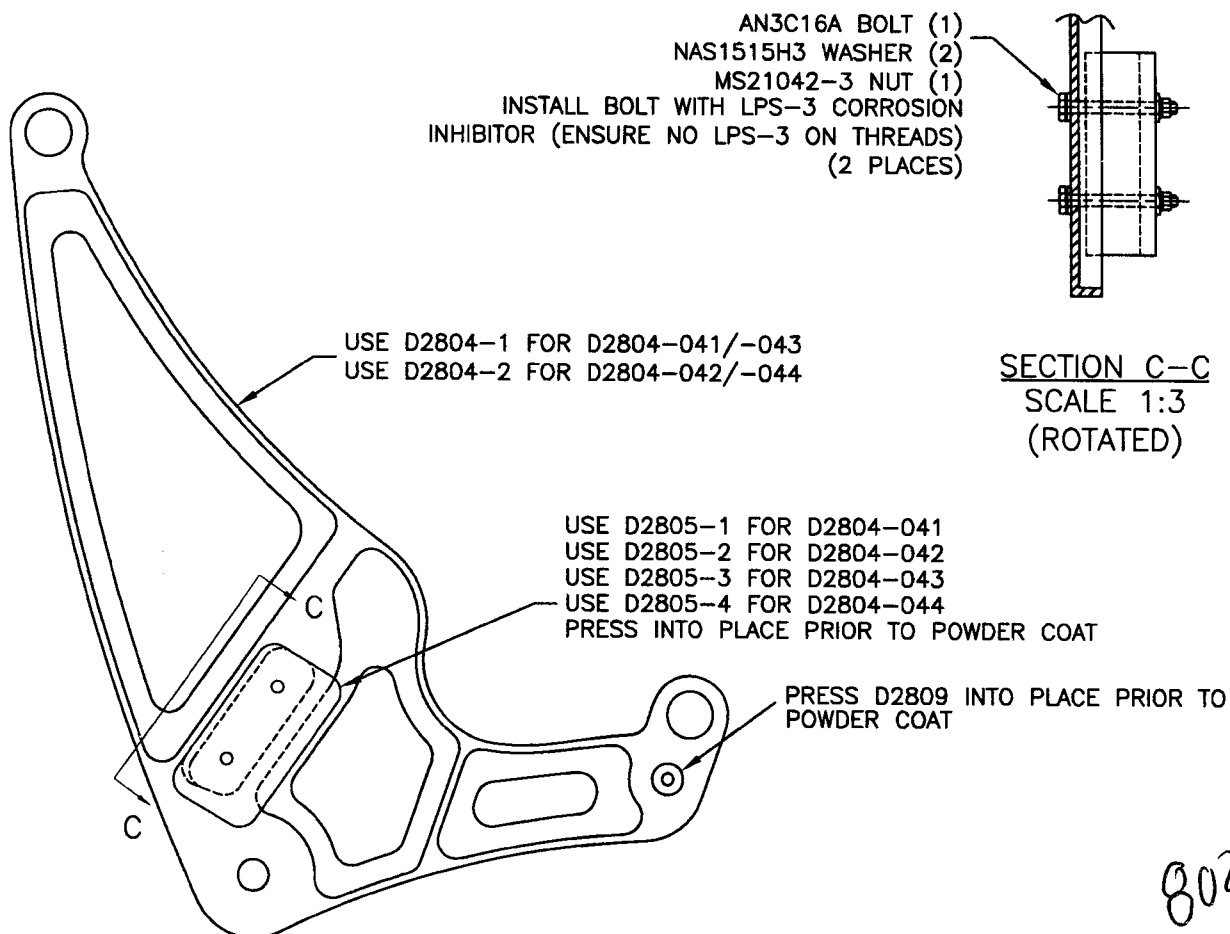
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07 [Signature]

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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